

538

DART AEROSPACE LTD		Work Order:	24142
Description: Folding Step Weldment LH		Part Number:	D3388-041
Dwg: D3388 Rev. A		Qty:	1
Page 1 of 1			

Step	Location	Procedure	By	Date	Qty												
1	DC	Issue Traveler Dwg not required	AP	05/09/07	1												
2	GA	Cut D2622-120C extrusion 85.15" long as per Dwg D3388 Batch: <u>B22364</u>	PD	05-11-8	1												
3	GA	Deburr and bevel ends for welding	PD	05-11-8	1												
4	WA	Weld arms and end caps as per Dwg D3388. Inspect for foreign objects as per QSI 024. Dwg Rev: <u>A</u> Pick: <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>2</td><td>D2734</td><td>End Cap</td><td><u>B20157</u></td></tr><tr><td>2</td><td>D3387-1</td><td>Arm</td><td><u>B24119</u></td></tr></table>	Qty	Part Number	Description	Batch	2	D2734	End Cap	<u>B20157</u>	2	D3387-1	Arm	<u>B24119</u>	PD	05-11-8	1
Qty	Part Number	Description	Batch														
2	D2734	End Cap	<u>B20157</u>														
2	D3387-1	Arm	<u>B24119</u>														
5	GA	Grind end cap welds flush	PD	05-11-8	1												
6	QC9/5	Inspect weld and work to Step 5	JA	05/11/10	1												
7	FP	Chemical Conversion Coat as per QSI 005 4.1	FC	05/11/10	1												
8	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	ML	05/11/16	1												
9	FP	Wing Walk as per Dwg D3388 and QSI 005 4.4	ML	05/11/17	1												
10	QC3	Inspect Powder Coat and Wing Walk	SB	05/11/18	1												
11	GA	Press spacer into D3387-1 arm as per Dwg D3387 Pick: <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>1</td><td>D2808</td><td>Spacer</td><td><u>B22862</u></td></tr></table>	Qty	Part Number	Description	Batch	1	D2808	Spacer	<u>B22862</u>	SB	05/11/18	1				
Qty	Part Number	Description	Batch														
1	D2808	Spacer	<u>B22862</u>														
12	QC5	Inspect work to Step 11	J	06-01-26	1												
13	ST	Identify and Stock	CL	06/01/26	1												
14	AC	Cost / part: _____	Sur	06-01-27	1												
15	DC	Close W/O Inspect Level 21	D	06/01/27	1												

Rev	Date	Change	Revised By	Approved
A	05.02.22	New Issue	KJ/JLM	
B	05.06.10	Added Step 11	KJ/JLM	

RELEASED
Full 5020

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 15 Date: 06/01/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

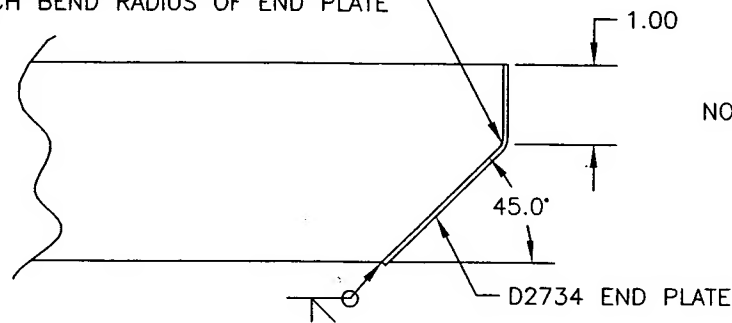


RELEASED

05.03.11

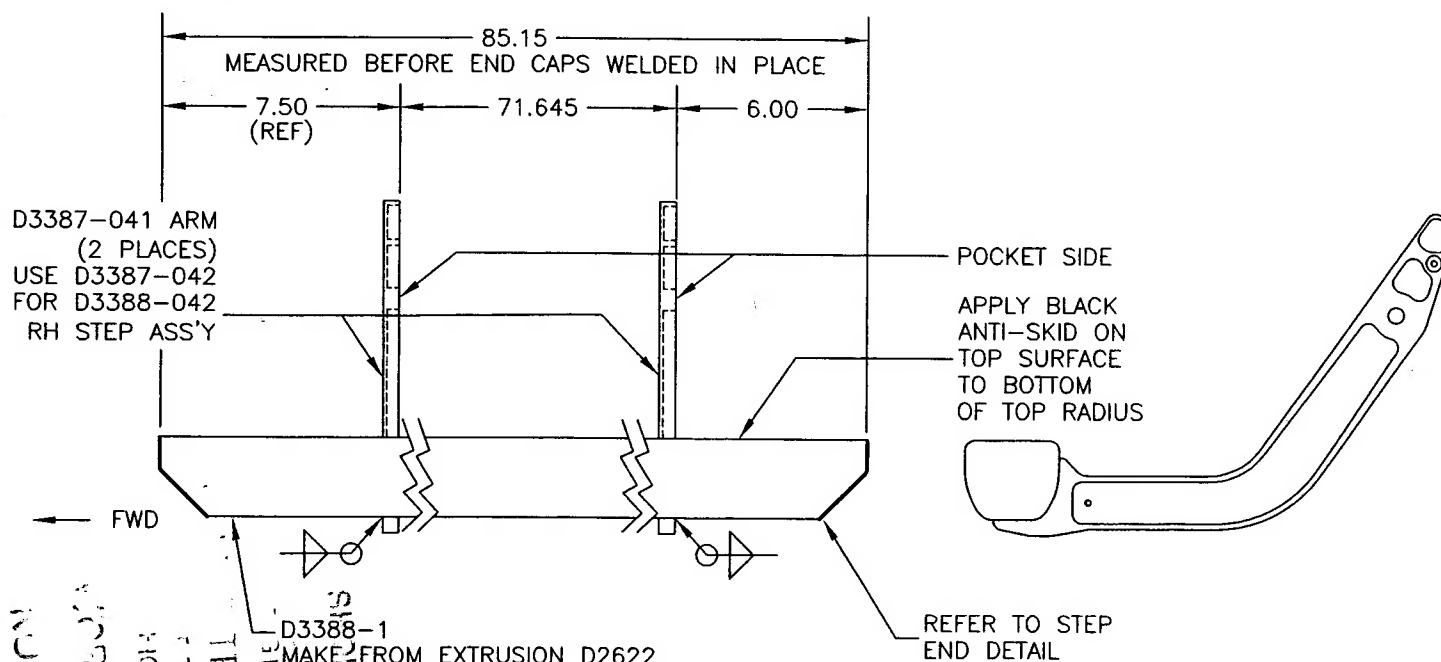
NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
CP	CP	D3388
DATE	TITLE	REV. A
05.01.20	STEP WELDMENT	SHEET 1 OF 1
A	05.01.20	NEW ISSUE
		SCALE NTS



D3388-041 LH STEP ASSEMBLY (SHOWN)
D3388-042 RH STEP ASSEMBLY (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

WORK ORDER
NOTICE
AMENDMENT

NO. 24142

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 01, 2005
10:48 am

Work Order No : 0024142
Project Name : D3388-041
Project For : WK538
Work Order Type : Main
Main WO Number :
House Part Number : D3388-041
Description : Step Weldment LH
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 08-29-05
Est Finish Date : 09-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
11:05 am

Work Order No : 0024142
Project Name : D3388-041
Project For : WK538
Work Order Type : Main
Main WO Number :
House Part Number : D3388-041
Description : Step Weldment LH
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 08-29-05
Est Finish Date : 09-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

MIS 2/B
w
11.15

Date: Monday, 14/11/2005 3:36:16 PM
 User: Alba Panzuto

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FOLDING STEP WELDMENT LH
Job Number :	24142		
Estimate Number :	10463		
P.O. Number :		Part Number :	D3388041
This Issue :	14/11/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3388 REV A
First Issue :	/ /	Project Number :	
Previous Run :	23632	Drawing Revision :	A
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	30/11/2005
Written By :		Qty:	1
Checked & Approved By :		Um:	Each
Comment :	Est. B 05.06.10 Added Step 11 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut D2622-120C extrusion 85.15" long as per Dwg D3388

Batch: _____

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

Deburr and bevel ends for welding

3.0	D2734	206 Step Endplate
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4.0	D33871	Arm
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5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

Weld arms and end caps as per Dwg D3388.

Inspect for foreign objects as per QSI 024. Dwg Rev: _____

Grind end cap welds flush

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Date: Monday, 14/11/2005 3:36:16 PM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOLDING STEP WELDMENT LH

Job Number: 24142

Part Number: D3388041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3388 and QSI 005 4.4

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect Powder Coat and Wing Walk

10.0

D2808

Spacer

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press spacer into D3387-1 arm as per Dwg D3387

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



5/29

DART AEROSPACE LTD	Work Order:	23632
Description: Folding Step Weldment LH	Part Number:	D3388-041
Dwg: D3388 Rev. A	Qty:	4
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty												
1	DC	Issue Traveler Dwg not required	PD	05.06.21	4												
2	GA	Cut D2622-120C extrusion 85.15" long as per Dwg D3388 Batch: <u>B22364</u>	PD	05.11.9	4												
3	GA	Deburr and bevel ends for welding	PD	05.11.9	4												
4	WA	Weld arms and end caps as per Dwg D3388. Inspect for foreign objects as per QSI 024. Dwg Rev: <u>A</u> Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D2734</td> <td>End Cap</td> <td><u>B20757</u></td> </tr> <tr> <td>2</td> <td>D3387-1</td> <td>Arm</td> <td><u>B24119</u></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	2	D2734	End Cap	<u>B20757</u>	2	D3387-1	Arm	<u>B24119</u>	PD	05.11.09	4
Qty	Part Number	Description	Batch														
2	D2734	End Cap	<u>B20757</u>														
2	D3387-1	Arm	<u>B24119</u>														
5	GA	Grind end cap welds flush	PD	05.11.09	4												
6	QC9/5	Inspect weld and work to Step 5	PD	05/11/10	4												
7	FP	Chemical Conversion Coat as per QSI 005 4.1	FC	05/11/15	4												
8	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	ML	05/11/16	4												
9	FP	Wing Walk as per Dwg D3388 and QSI 005 4.4	ML	05/11/17	4												
10	QC3	Inspect Powder Coat and Wing Walk	SB	05/11/18	4												
11	GA	Press spacer into D3387-1 arm as per Dwg D3387 Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2808</td> <td>Spacer</td> <td><u>B22682</u></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D2808	Spacer	<u>B22682</u>	SB	05/11/18	4				
Qty	Part Number	Description	Batch														
1	D2808	Spacer	<u>B22682</u>														
12	QC5	Inspect work to Step 11	J	06.01.26	4												
13	ST	Identify and Stock															
14	AC	Cost / part: _____															
15	DC	Close W/O Inspect Level 21															

Rev	Date	Change	Revised By	Approved
A	05.02.22	New Issue	KJ/JLM	
B	05.06.10	Added Step 11	KJ/JLM	

RELEASED
JUL 15 2022

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

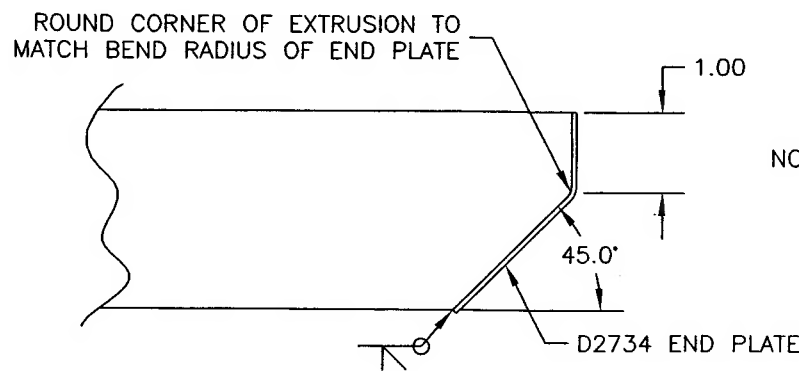
QA: N/C Closed: _____ Date: _____



RELEASED

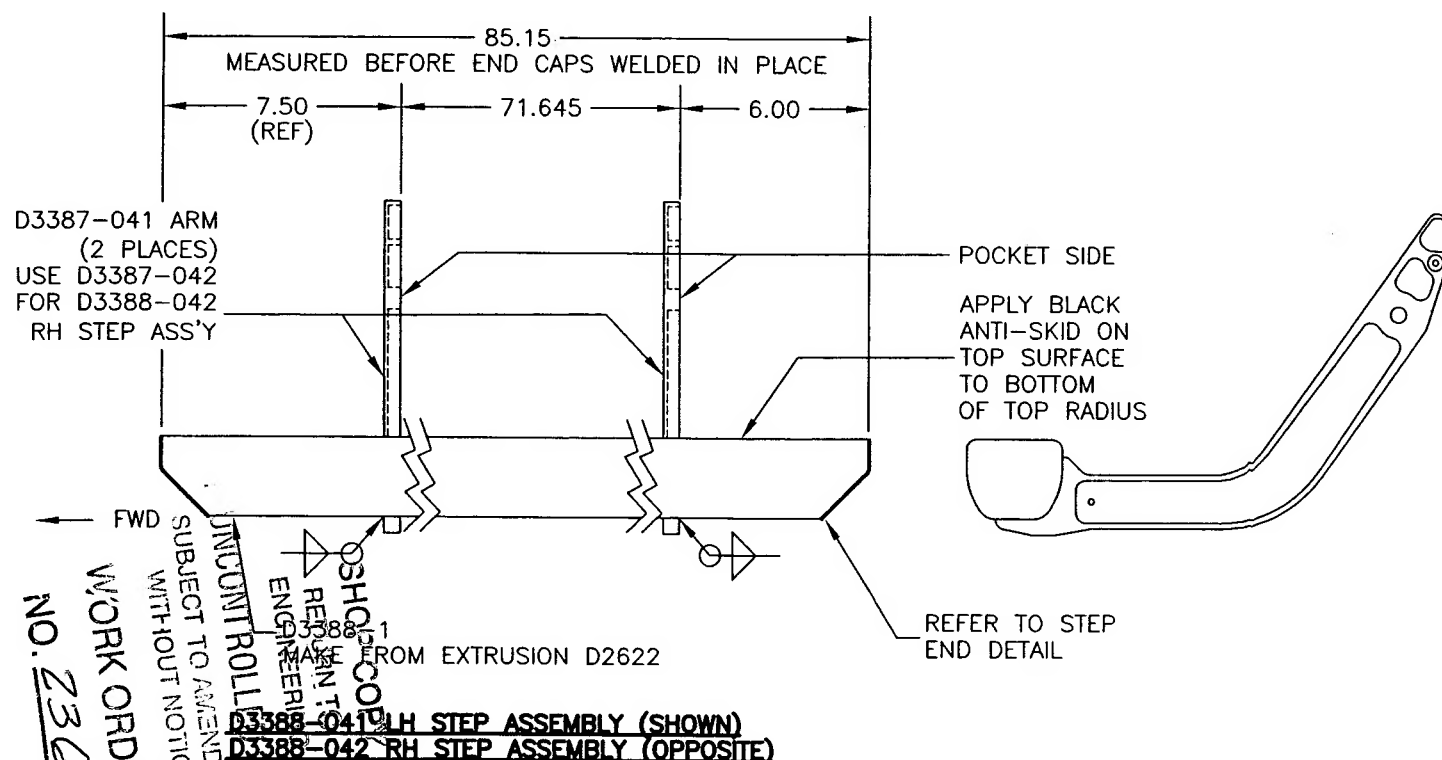
05.03.11

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE

DESIGN	AP	DRAWN BY	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	APPROVED	AP	DRAWING NO. D3388
DATE	05.01.20	TITLE	STEP WELDMENT	REV. A
A	05.01.20	SCALE	NTS	SHEET 1 OF 1



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 20, 2005

03:23 pm

Work Order No : 0023632
Project Name : D3388-041
Project For : WK529
Work Order Type : Main
Main WO Number :
House Part Number : D3388-041
Description : Step Weldment LH
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 06-20-05
Est Finish Date : 07-23-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00